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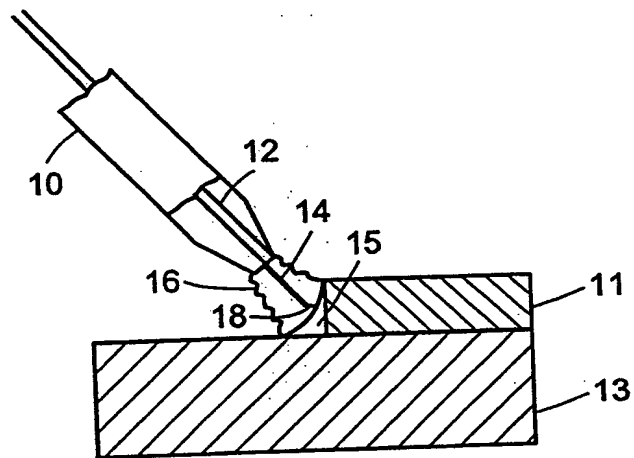


FIG. 1

Test Number --- 2797D-2-001A

Specimen Number -- P23222

Charpy V-Notch Toughness Using 100% Argon Shielding

Temperature, Degrees F	0	0	0	0	0	-20	-20	-20	-20	-20
Foot Pounds	71	61	57	65	50	41	47	50	53	56

Oxygen In Weld Deposit = .05220

Specimen Number -- P23225

Charpy V-Notch Toughness Using 90% Argon & 10% CO2 Shielding

Temperature, Degrees F	0	0	0	0	0	-20	-20	-20	-20	-20
Foot Pounds	39	54	28	50	40	31	38	35	28	32

Oxygen In Weld Deposit = .05920

Fig. 2

Untitled
FUME CHAMBER TESTING

DATE	08/28/2003	SPEC NO	F11649	TYPE	
SIZE	.052	CLASS		CO/LOG	PROJ#
SHEET/DEV		TEST/SER	2797D-1-001	WELDED BY	KEB
FM SPEC		ENGR	DLD	CURRENT	DCEP
WFS	338	AMPS	300	VOLTS	25.0
ELECTRODE ANGLE	90	TRAVEL (IPM)	14.0	ESO	1.000
AIR FLOW (CFH)	45.00			GAS	ARGON
				DURATION (MIN)	0.50
				MATERIAL TYPE	W

FOLLOWING RESULTS ARE AN AVERAGE OF THREE TESTS

% FUME	0.23	FGR (GMS/MIN)	0.20	MELT RATE (LB/HR)	11.62
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Fig. 3

Untitled
FUME CHAMBER TESTING

DATE	08/28/2003	SPEC NO	F11650	TYPE	
SIZE	.052	CLASS		CO/LOG	PROJ#
SHEET/DEV		TEST/SER	2797D-1-001		WELDED BY KEB
FM SPEC		ENGR	DLD		CURRENT DCEP
WFS	338	AMPS	300	VOLTS	25.0
				ESO	1.000
				GAS	90/10
ELECTRODE ANGLE	90	TRAVEL (IPM)	14.0	DURATION (MIN)	0.50
AIR FLOW (CFH)	45.00			MATERIAL TYPE	W

FOLLOWING RESULTS ARE AN AVERAGE OF THREE TESTS

% FUME	0.64	FGR (GMS/MIN)	0.55	MELT RATE (LB/HR)	11.35
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Fig. 4

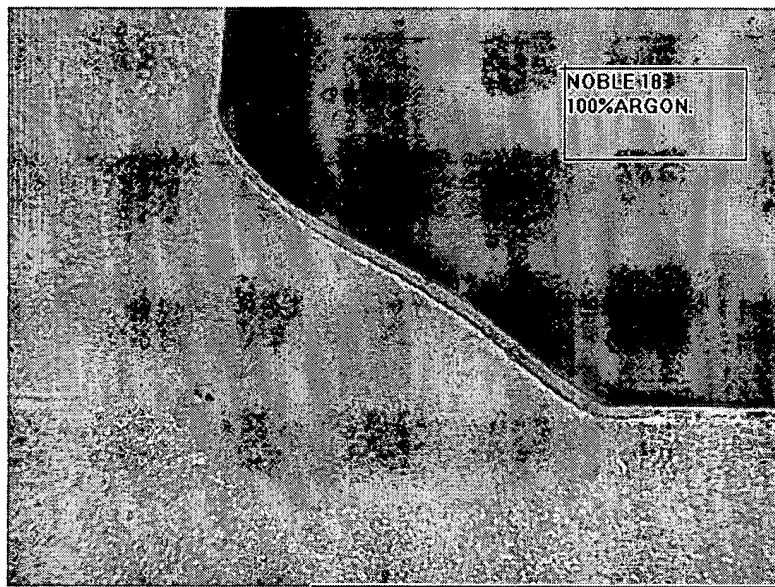


Fig. 5

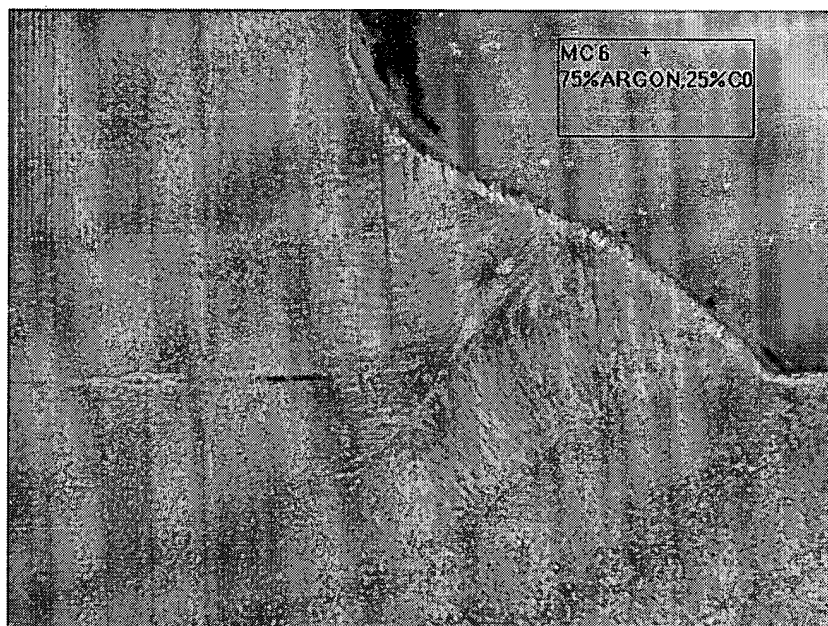


Fig. 6



Fig. 7



Fig. 8

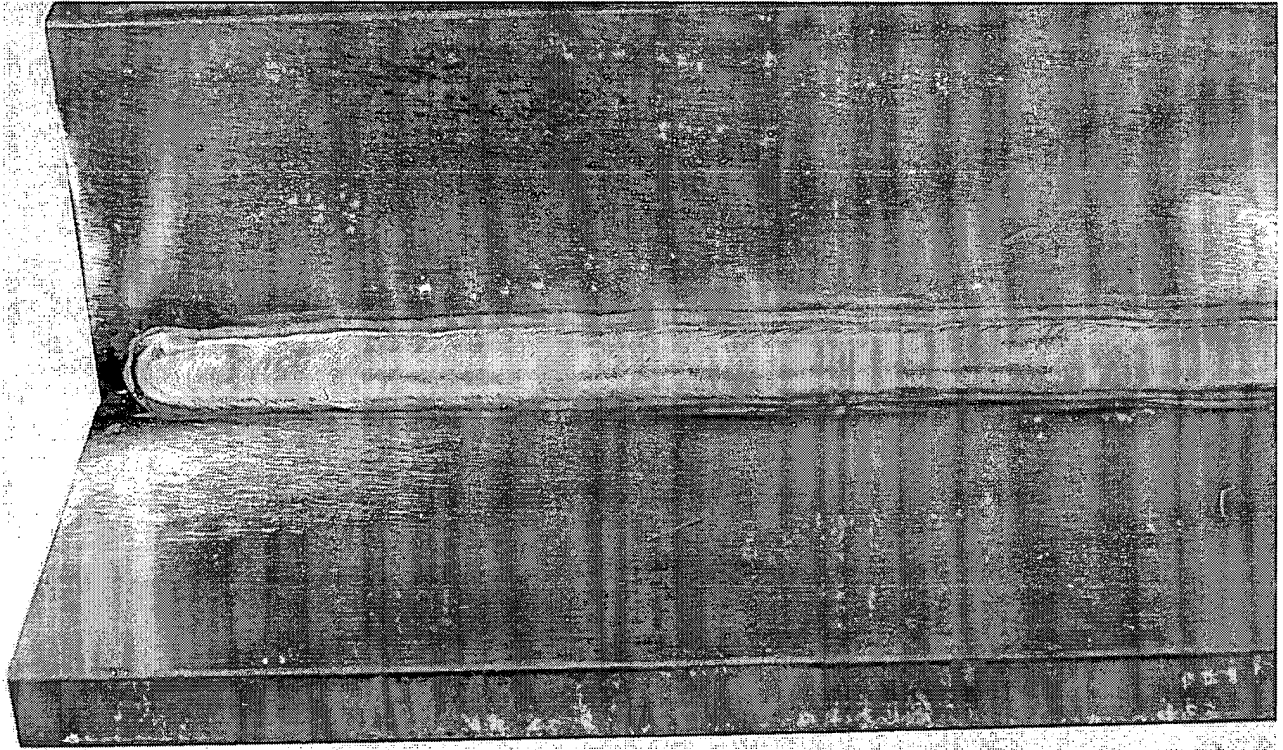


Fig. 9

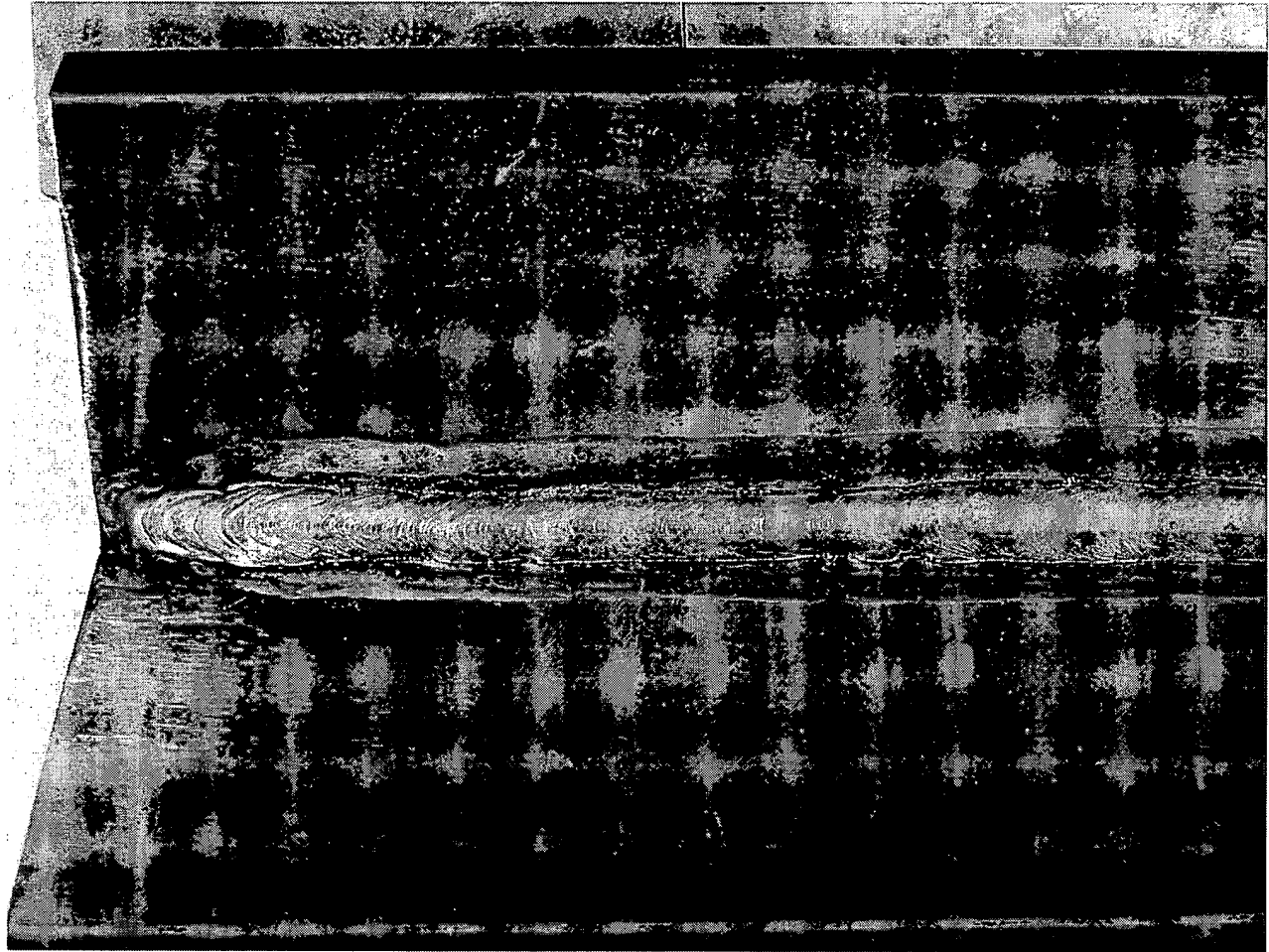


Fig. 10

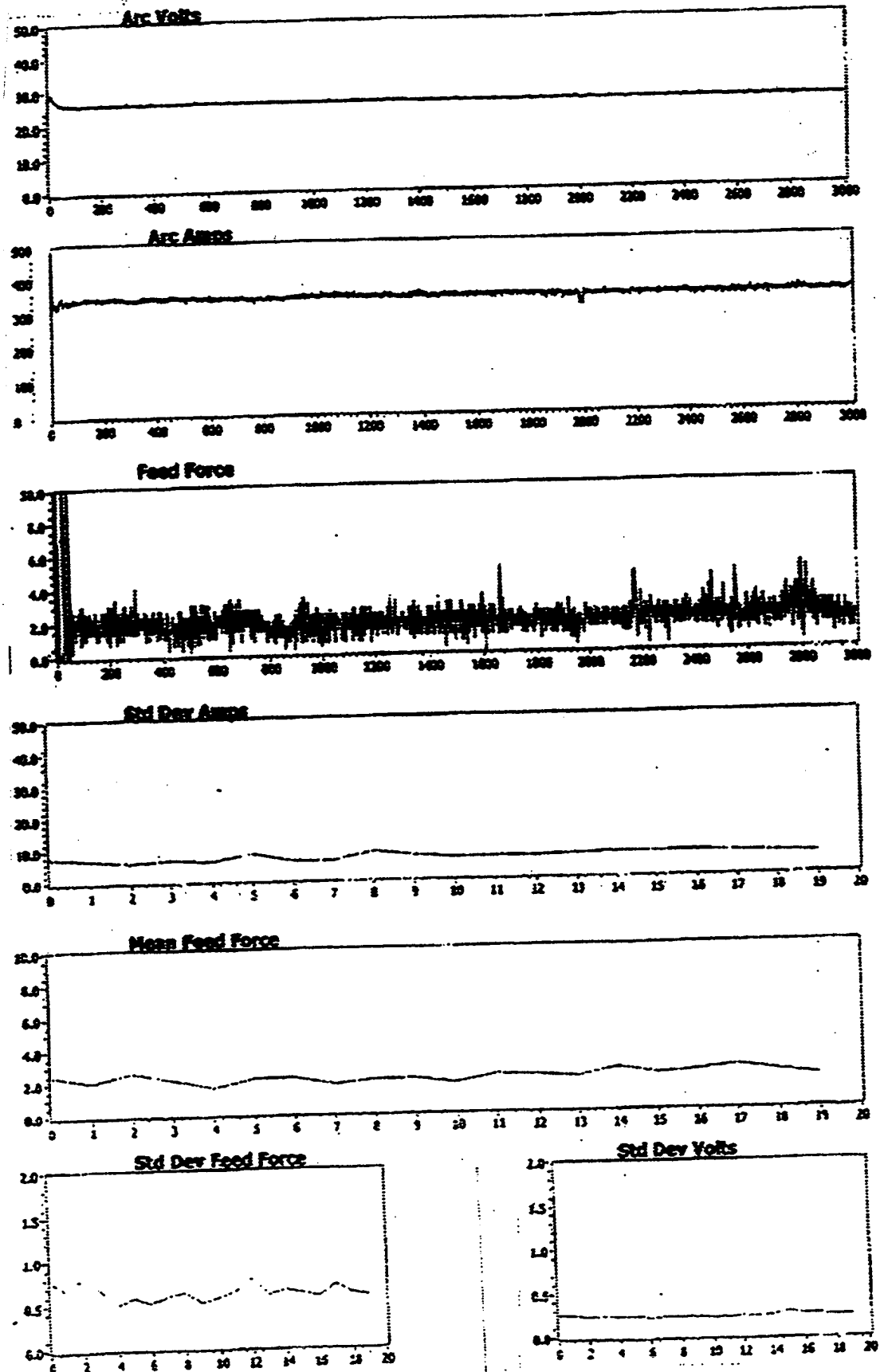


Fig. 11

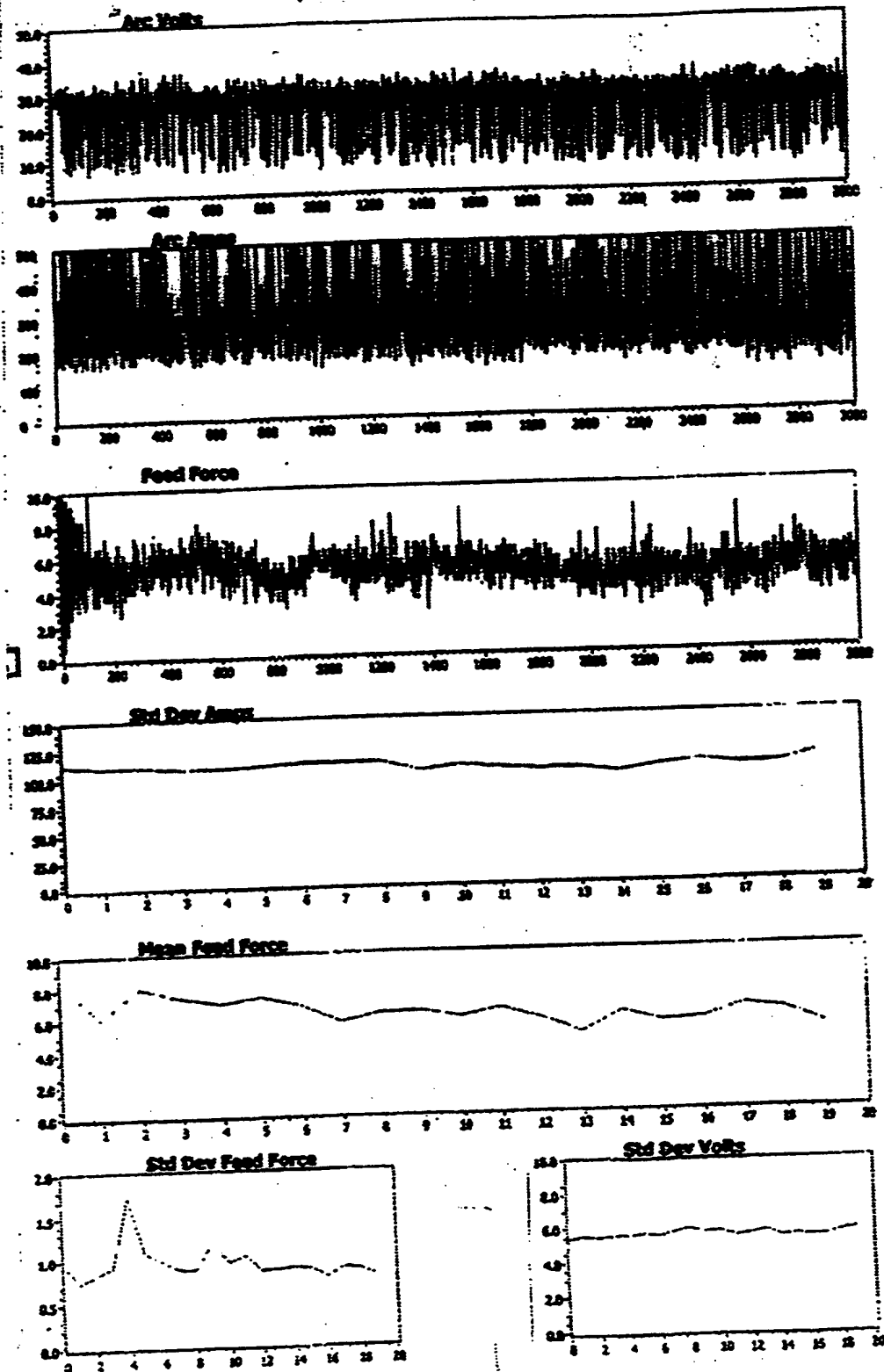


Fig. 12